

Date: Friday, 9/29/2006 10:42:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP WELDMENT		
Job Number	: 28788			Part Number	: D2563		
Estimate Number	: 10176			Drawing Number	: D2563 REV C		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 9/29/2006 S.O. No. : N/A			Drawing Revision	: C		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 10/10/2006		
Previous Run	: 27646			Qty:	2 Um: Each		
Written By	: <i>[Signature]</i>						
Checked & Approved By	: <i>[Signature]</i>						
Comment	: Est Rev:G 02/07/31 Re-format Location RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: 1 D2244 Step Extrusion	<i>(P.E. 06-10-02)</i>
		Batch: <i>323404</i>	
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: Qty Part No. Description	<i>(P.E. 06-10-03)</i>
		2 D2673-34 End Cap	<i>2 extra for my test</i>
		Batch <i>325396</i>	<i>(P.E. 06-10-02)</i>
3.0	D2561	Lug Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: Qty Part No. Description	<i>(P.E. 06-10-03)</i>
		2 D2561 Lug Plate	<i>1 extra for my test</i>
		Batch <i>3254461</i>	<i>(P.E. 06-10-02)</i>
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: Qty Part No. Description	<i>(P.E. 06-10-03)</i>
		2 D2564 Mounting Angle	<i>2 extra for my test</i>
		Batch <i>3274418</i>	<i>(P.E. 06-10-02)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

1E. 06.10.02

2-Deburr ends

- 1E. 06.10.02

3-Weld (1 End Only) as per Dwg D2563 using DT 8343

1E. 06.10.03

A/R AL ROD Batch: m15689 m19612

1E. 06.10.03

4-Grind

1E. 06.10.03

6.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

1A. 06/10/11 (2)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 14 (2)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1E. 06.10.17

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

1E. 06.10.17

2-Weld Remaining End as per Dwg D2563 using DT 8343

1E. 06.10.17

A/R AL ROD Batch: m18838 m19612

3-Grind

1E. 06.10.17

10.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Job 10-20

1A. 06/10/18 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/13
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Touch up Alodine then a.m 06/11/07 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	(2)
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D2563 and QSI 005 4.4	
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



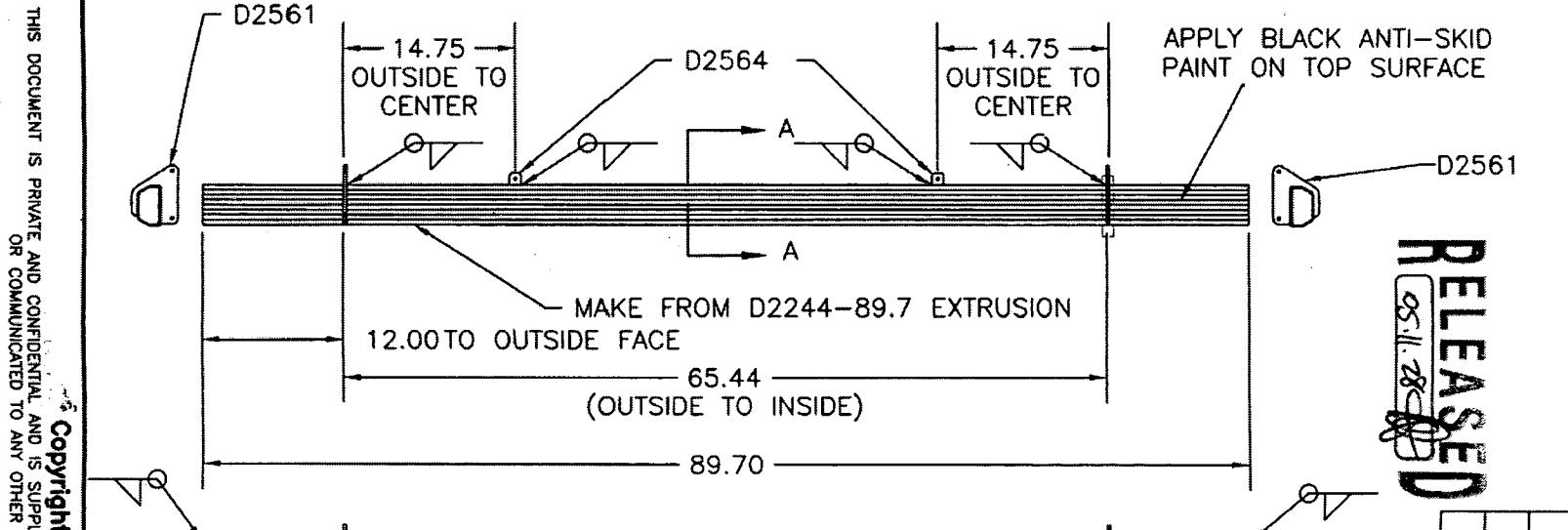
C Loc 11113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



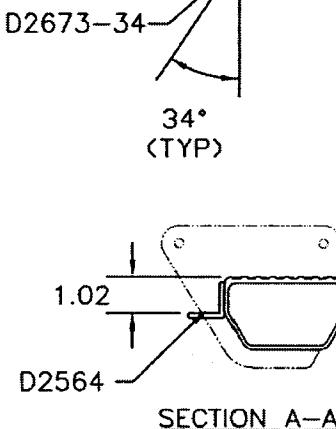
RELEASED
05.11.2003

D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG-PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

WORK ORDER NO. 2888
CONTROLED CO-
NTRAL ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE
SUBJECT TO AMENDMENT
BY DART AEROSPACE LTD



DART

DESIGN
BW DRAWN BY *PF* DART AEROSPACE LTD
CHECKED APPROVED DRAWING NO. D2563
DATE 05.11.14 TITLE STEP WELDMENT ASSEMBLY SHEET 1 OF 1
SCALE 1:15

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Material Requisitions

R/S#: _____

Part Number: J2561

Batch Number: 324461

Quantity: 1

Required by: IE Date: 06-10-03

Used for

Part Number: J2563

B28788

Batch Number: 324461

Approved by Purchaser: _____

Date: _____

Comments:

used for weld test

Material Requisitions

R/S#: _____

Part Number: J2673-34

Batch Number: 325396

Quantity: 2

Required by: DE Date: 06-10-03

Used for

Part Number: J2563

Batch Number: 328188
~~325396~~

Approved by Purchaser: _____

Date: _____

Comments:

used for weld test.

NO. 26

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Pat Ewers
Joint Welding Procedure JIC
Part number and Job number A2563 / B28788

TEST WELDS REQUIRED

BASE METAL	WELDING PROCESS			
	Single Weld	Double Weld	Backing YES	Backing NO
Penetration	Complete <input type="checkbox"/>	Partial <input type="checkbox"/>		
Current AC	<input type="checkbox"/>	<input type="checkbox"/>		
Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass Fail
Penetration Pass Fail

Crossbolt Spacer Pass Fail

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/04 Qualifier Paul Ewers